

SP/11

Work Order ID 51125 - 2

August 4, 2009 11:05:21 AM

Page 1

Item ID: D3065-041

Accept

Revision ID: B

Item Name: Step Leg Assembly Hi

Start Date: 8/21/09

Start Qty: 40.00

Required Date: 9/04/09

Req'd Qty: 40.00

Reference:

Approvals:

Process Plan: mf

Date: 09-08-04 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D3065

Rev B

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble as per Dwg D3065 and Identify as D3065-041

110

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

120

0.00



Packaging

Identify as per dwg &amp; Stock Location: WA

Memo

0.00

Packaging

09/09/18 (20)

2) Sorlos

counted  
(20) p

SAD 09-09-21

(200)

# Work Order ID 51125

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Page 2

Item ID: D3065-041  
Revision ID: B  
Item Name: Step Leg Assembly Hi

Accept



Setup Start



Stop



Start Date: 8/21/09 Start Qty: 40.00  
Required Date: 9/04/09 Req'd Qty: 40.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:  
QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/09/21 HJ

MF  
09-09-21

# Picklist Print

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Work Order ID: 51125



Parent Item: D3065-041RevB



Parent Item Name: Step Leg Assembly Hi

Start Date: 8/21/09

Required Date: 9/04/09

Comments:

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3065-1RevB

Manufactured

No

100

Each

70.0000

40.0000



Step Spacer

GP 09/09/17

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

GA

-20

46333

-20

Main Warehouse

ST

90

46333

39

48113

51

20

D3065-3RevB

Manufactured

No

100

Each

90.0000

40.0000



Step Spacer

GP 09/09/17

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

GA

60

48113

-20

50144

80

Main Warehouse

ST

30

48113

30

20

# Picklist Print

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Page 2

Work Order ID: 51125

Parent Item: D3065-041RevB

Parent Item Name: Step Leg Assembly Hi

Comments:

Start Date: 8/21/09

Required Date: 9/04/09

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3065-5RevB

Manufactured No

100

Each

0.0000

80.0000



Step Leg

*EP 09/09/17*

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

GA

-40

50145

-40

Main Warehouse

ST

40

50145

40

D3065-7RevB

Manufactured No

100

Each

171.0000

40.0000



Step Spacer

~~40~~

*EP 09/09/17*

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

GA

-20

45395

-20

Main Warehouse

ST

191

44395

34

45395

18

46333

49

48113

50

50146

40

~~30~~

August 4, 2009 11:05:20 AM

Shop Packet Print

Page 2



# Picklist Print

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Page 3

Work Order ID: 51125

Parent Item: D3065-041RevB

Parent Item Name: Step Leg Assembly Hi

Comments:

Start Date: 8/21/09

Required Date: 9/04/09

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

MS20470AD4-4

Purchased

No

100

Each

7,162.000

1,200.0000



Rivet, Universal Head

*EP 09/09/17*

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

7162

111359

2162

112314

5000

600

August 4, 2009 11:05:20 AM

Shop Packet Print

Page 3

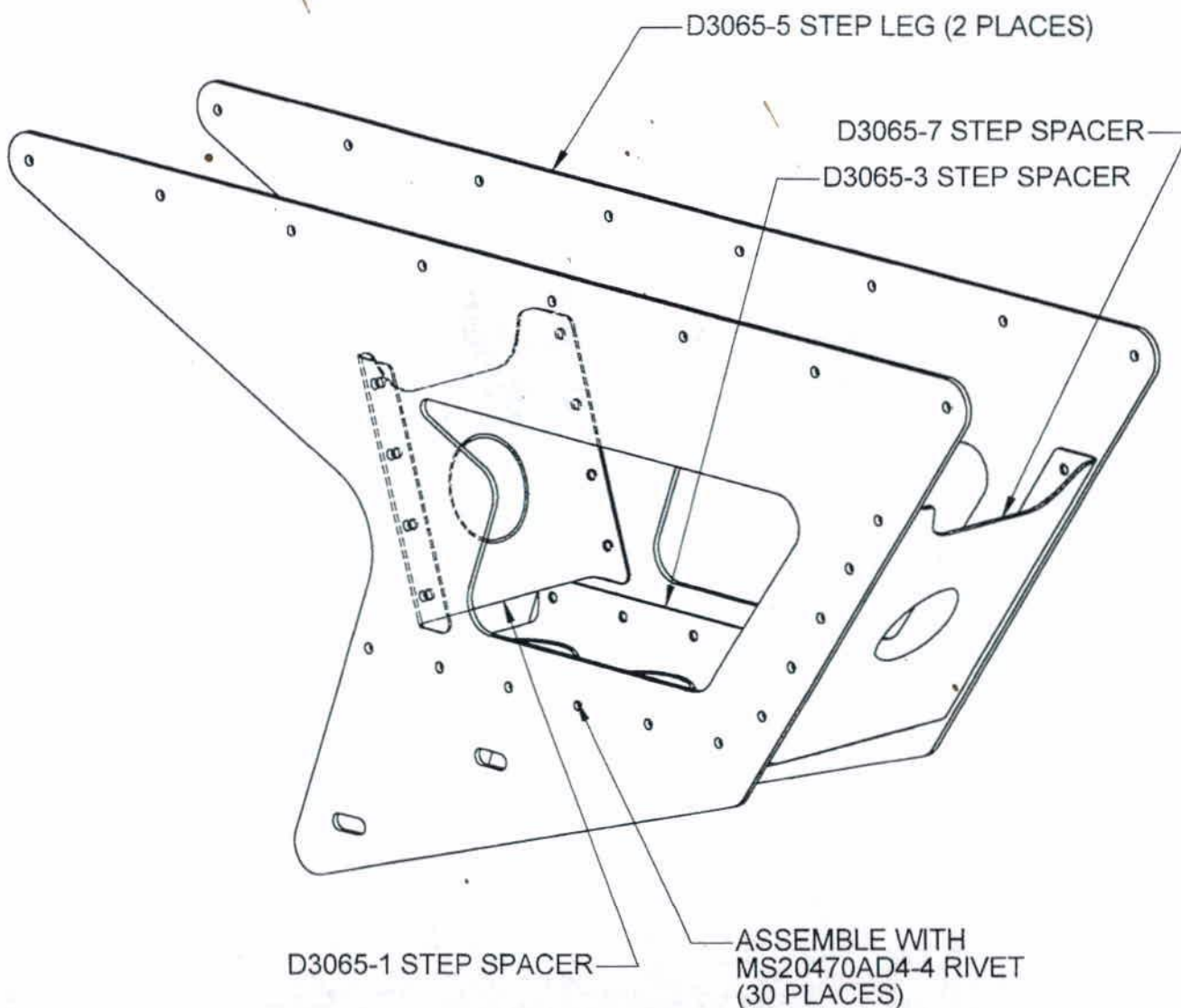


DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 1 OF 5
DATE 06.05.23	TITLE STEP LEG ASSEMBLY		SCALE 1:2
A	02.09.11	NEW ISSUE	
B	06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5	

RELEASED

06.06.20 *[Signature]*

#51125  
MF  
09-08-04



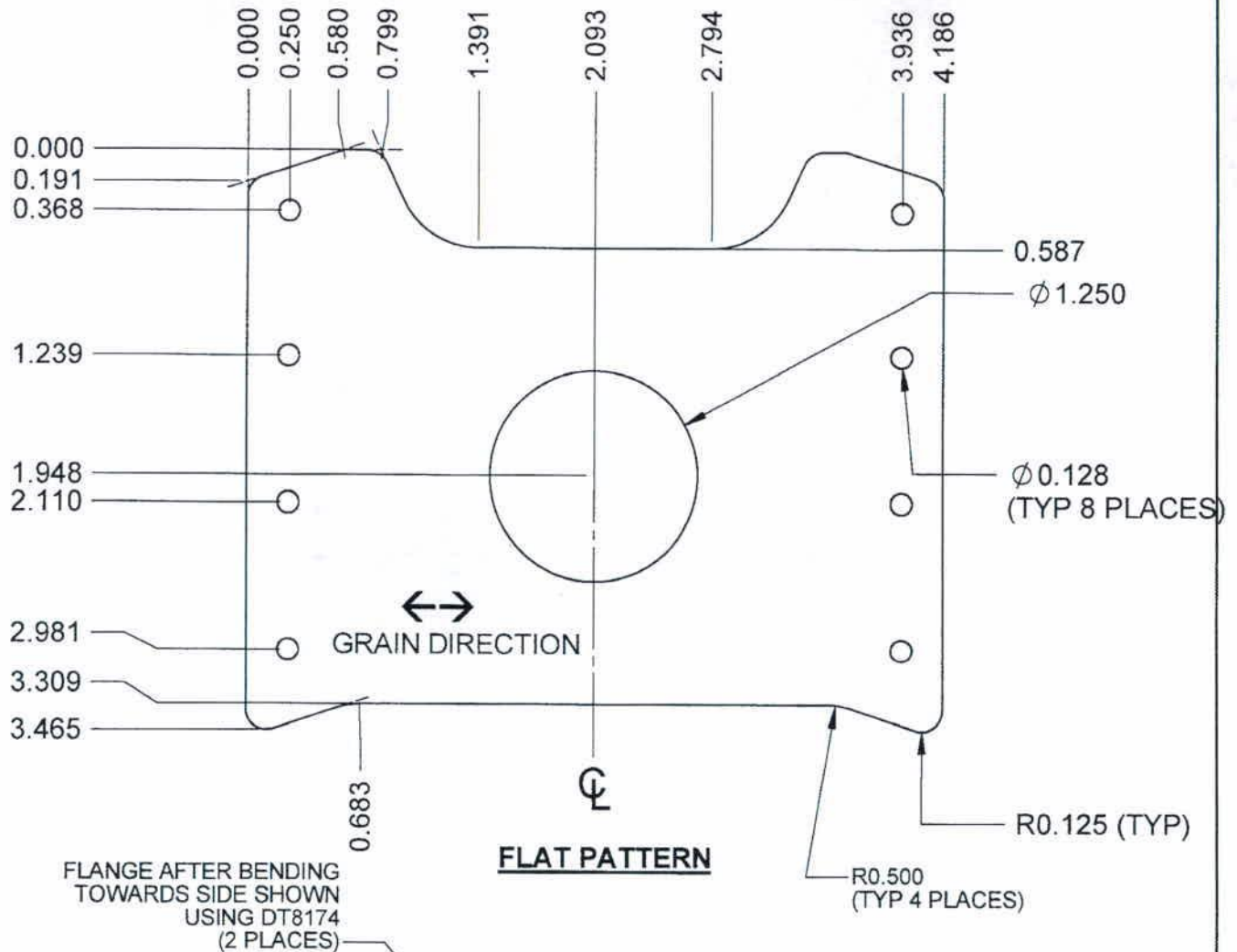
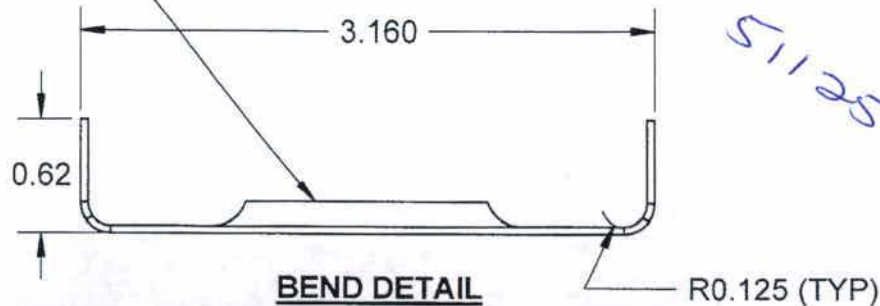
## D3065-041 STEP LEG ASSEMBLY

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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 2 OF 5
DATE 06.05.23	TITLE STEP LEG ASSEMBLY		SCALE 1:1

**RELEASED***de de re***D3065-1 STEP SPACER**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

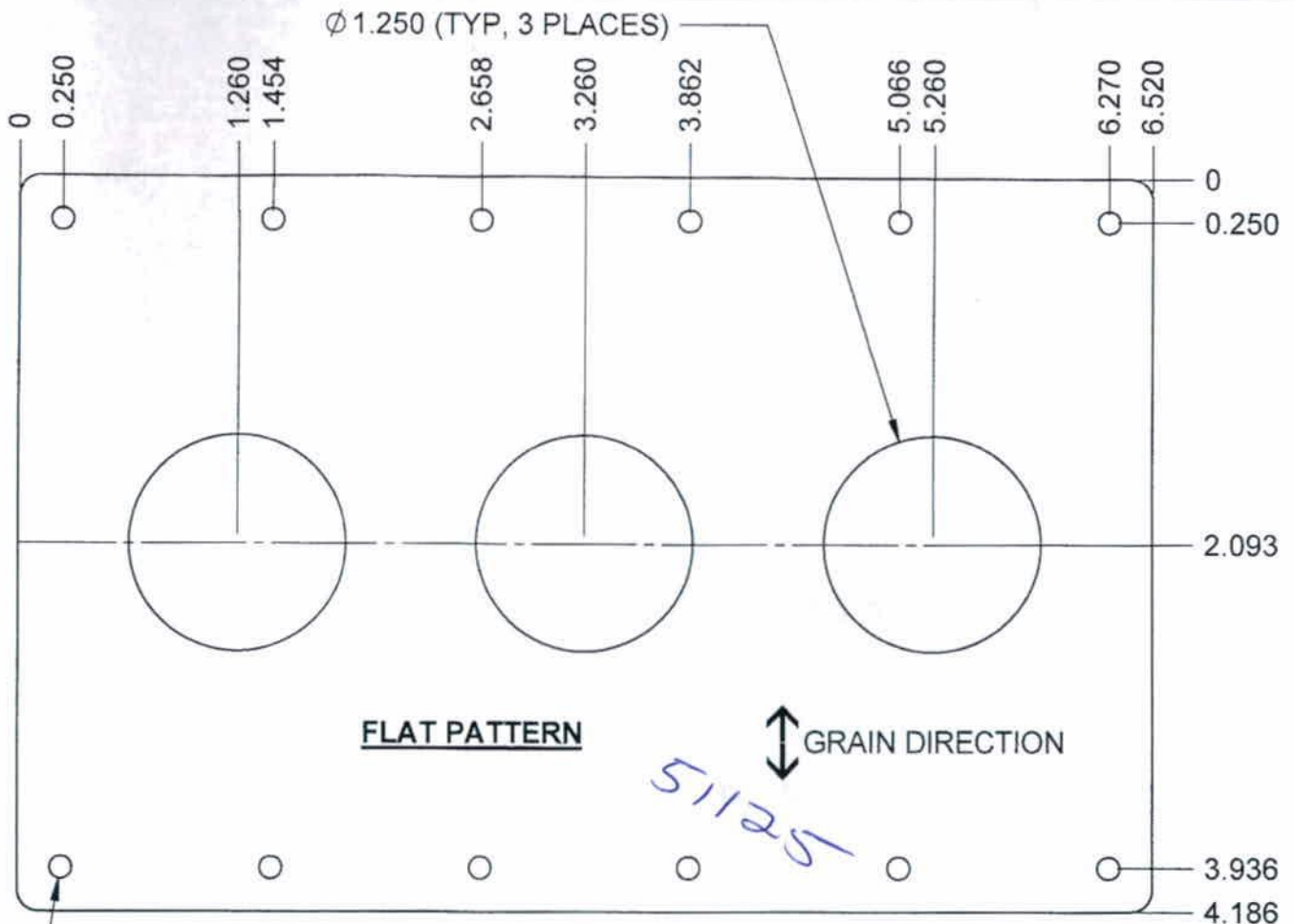
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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 3 OF 5
DATE 06.05.23	TITLE STEP LEG ASSEMBLY		SCALE 1:1

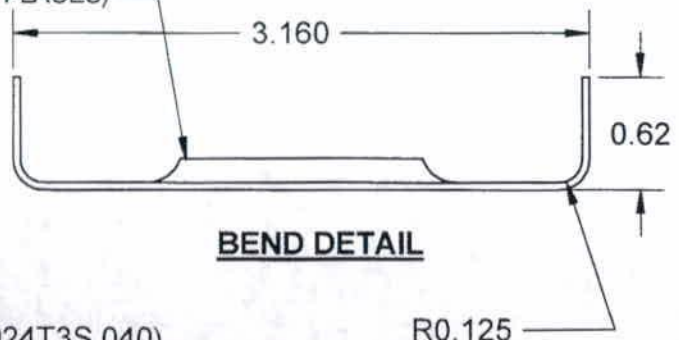


FLANGE AFTER TOWARDS SIDE  
SHOWN USING DT8174 (3 PLACES)

Ø 0.129 (TYP, 12 PLACES)

**RELEASED**

*de de 20* *[Signature]*



**BEND DETAIL**

**D3065-3 STEP SPACER**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4)  
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

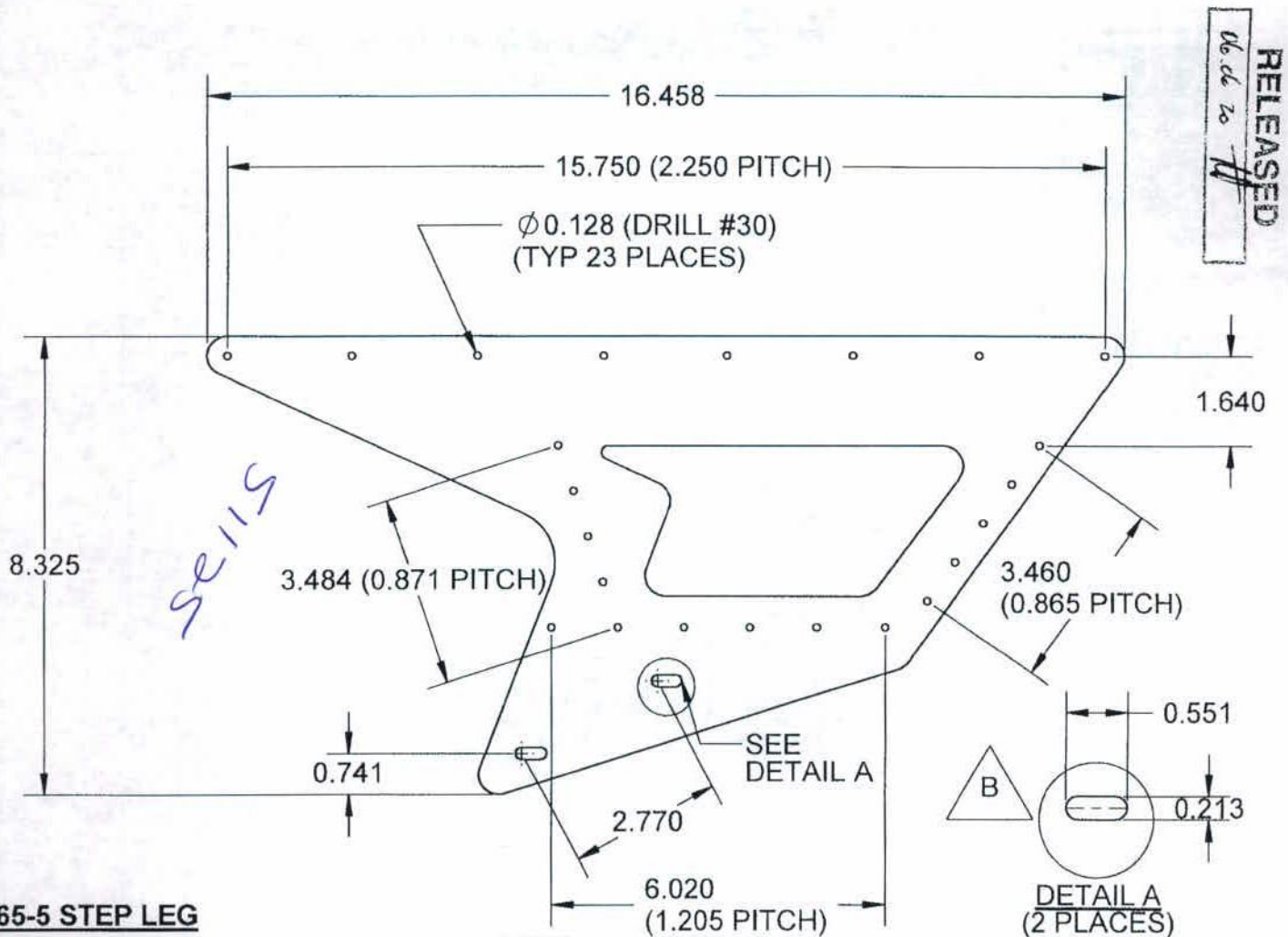
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DESIGN	<i>CP</i>	DRAWN BY	<i>C.B.</i>	<b>DART AEROSPACE LTD</b>
				HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>PH</i>	APPROVED	<i>PH</i>	DRAWING NO. <b>D3065</b>
DATE	06.05.23			REV. B
				SHEET 4 OF 5
				SCALE 1:3
				TITLE STEP LEG ASSEMBLY

**D3065-5 STEP LEG**

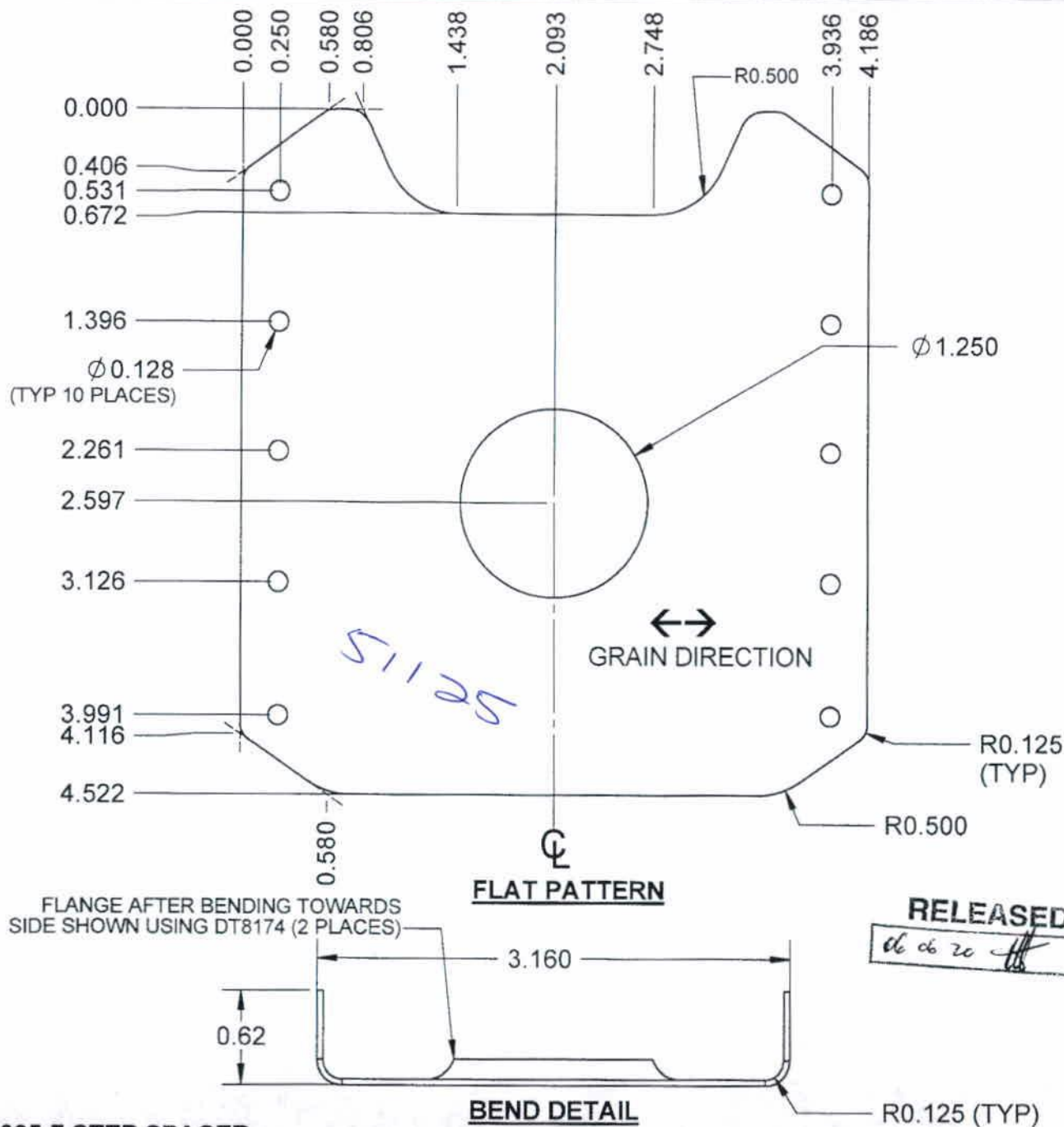
- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
- 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK  
(REF DART SPEC M6061T6S.080)  
OR  
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3065</b>	REV. B SHEET 5 OF 5
DATE <b>06.05.23</b>	TITLE <b>STEP LEG ASSEMBLY</b>		SCALE 1:1

**RELEASED***de de 20***D3065-7 STEP SPACER**

- 1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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